

**ABSTRACT**

An optical focusing system is configured to generate a data profile, wherein the data profile is configured to provide signals for operation of an actuator. Application of the signals from the data profile results in focus of  
5 optics within a label region of an optical disc. An image is printed on the label region of the optical disc while the optics focus on the label region of the optical disc by applying signals to the actuator according to the data profile.